

Work Order ID 67630

Monday, March 28, 2011 3:20:46 PM

Page 1

Item ID: D4037-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Crossbeam

Start Date: 3/28/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan: MLF

Date: 11-03-28 Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4037

C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut blank as per file D4037-1_BLANK

AB 11-3-24

②

110

0.00



HAAS J

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLI FA877 AND DWG

FOLIO REV: AA

DWG REV: C

DEBURR

B.A 11/03/30

2 6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

L.A 11/03/30

2

0

Memo


0.00

130



QC

Quality Control

ACB 
Memo

0.00

ML 11/04/01

2

0

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

R 0 ML 11/04/04

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Page 3

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Stop



Start Date: 3/28/2011 Start Qty: 2.00



Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

M1159SL

2 BL 11-4-4

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

2 φ 11/04/04

170



Packaging

Packaging

Identify as per dwg & Stock Location 20

0.00

Memo

0.00

10/4/5 2

W/O:		WORK ORDER CHANGES						
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Page 4

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

n/4/5

U 6604.05

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Picklist Print

Monday, March 28, 2011 3:20:40 PM

Page 1

Work Order ID: 67630



Parent Item: D4037-1



Parent Item Name: Aft Crossbeam

Start Date: 3/28/2011

Required Date: 4/4/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 09-12-14 JLM VERIFIED BY:EC IPP
REV:B AS PER REV B 10-04-19 JLM VERIFIED BY:EC IPP REV
C:AS PER ECN 10-563 10-09-28 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X15.00 0		Purchased		No		100	f	31.5000	3.9	8.210526			



6061-T6 Bar 1.00 x 15.00



B11-3-24

Location

Loc Qty

Loc Code

MAT005

31.5

114899

12

115093

4.5

115173

12

9544

3

114899

(2)

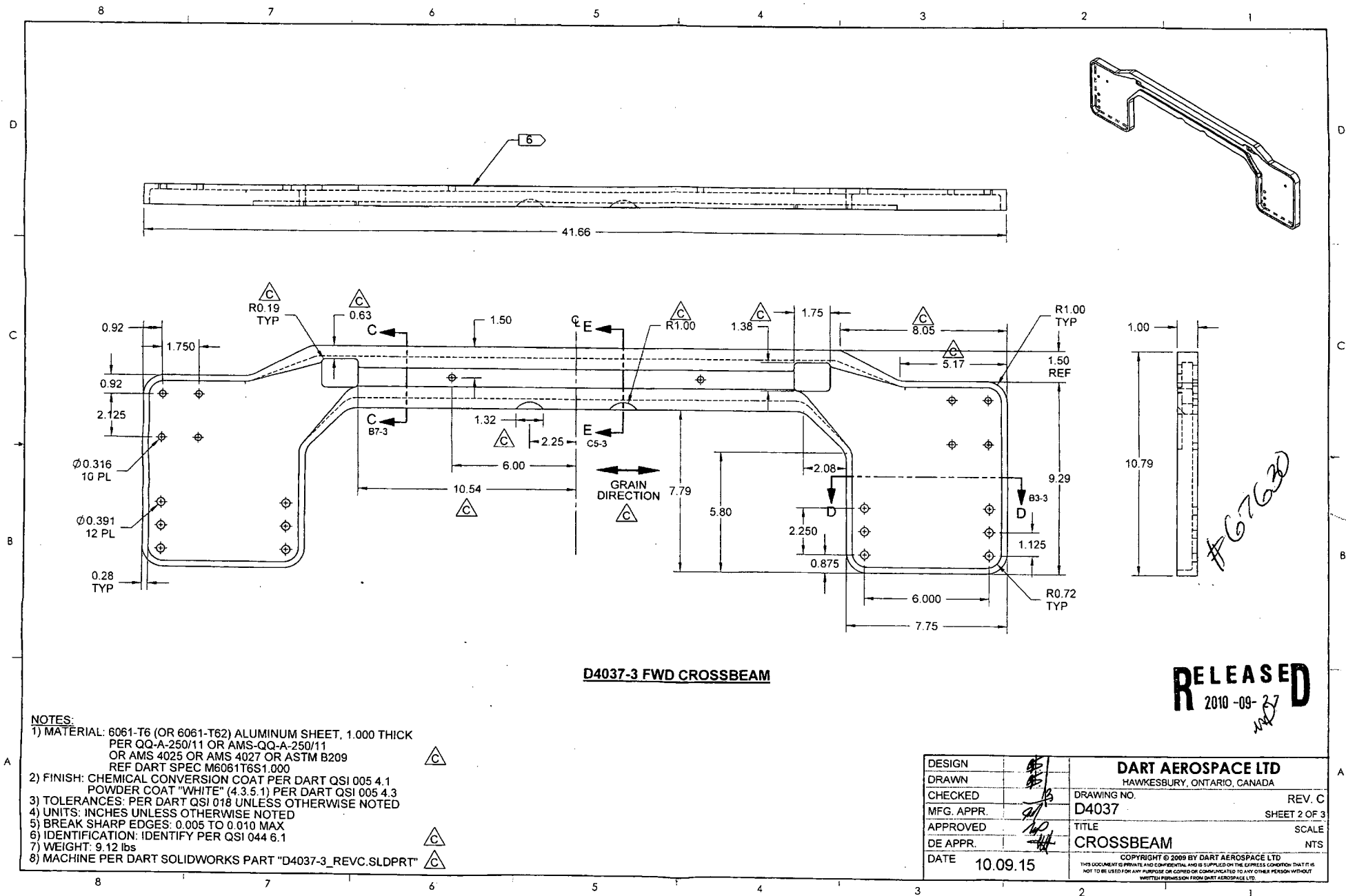
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NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 1.000 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 9.12 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4037-3_REVC.SLDPRT"

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4037	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CROSSBEAM	NTS
DATE	10.09.15	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

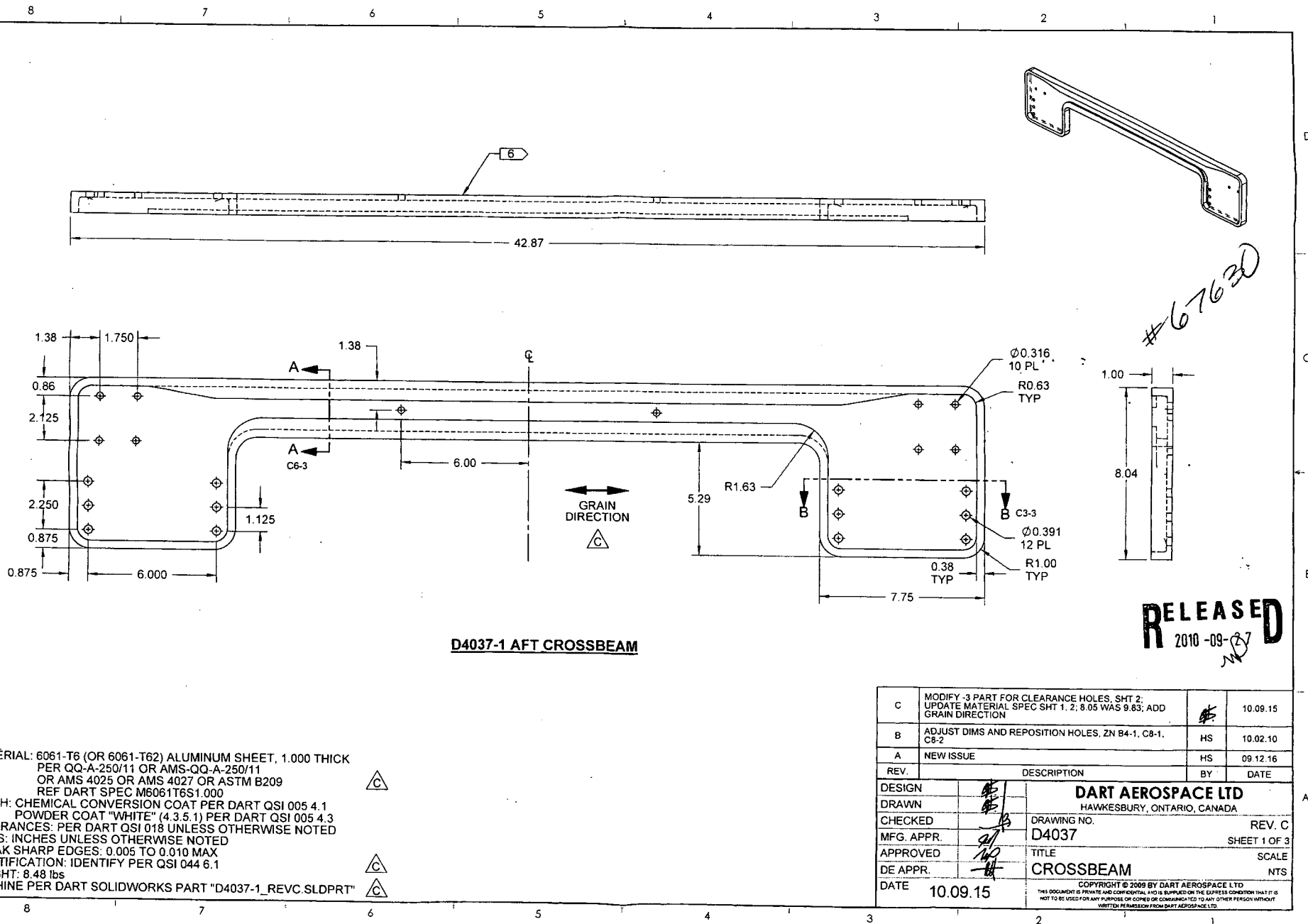
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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.48 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4037-1_REVC.SLDPRT"

C	MODIFY -3 PART FOR CLEARANCE HOLES, SHT 2; UPDATE MATERIAL SPEC SHT 1, 2; 8.05 WAS 9.63; ADD GRAIN DIRECTION	HS	10.09.15
B	ADJUST DIMS AND REPOSITION HOLES, ZN B4-1, C8-1, C8-2	HS	10.02.10
A	NEW ISSUE	HS	09.12.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.09.15		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4037 TITLE CROSSBEAM REV. C SHEET 1 OF 3 SCALE NTS <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONVEYED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

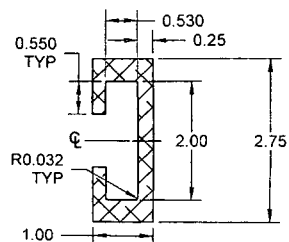
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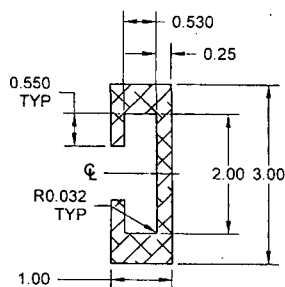
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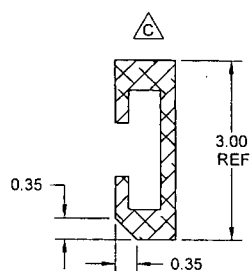
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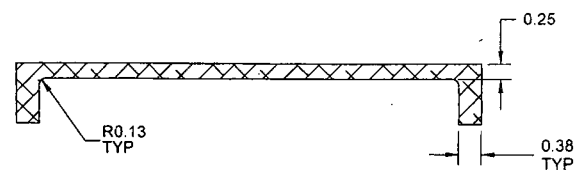
SECTION A-A B6-1
SCALE 2X



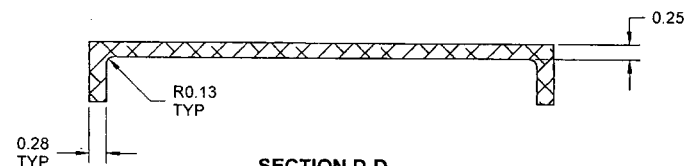
SECTION C-C B6-2
SCALE 2X



SECTION E-E C5-2
SCALE 2X



SECTION B-B B2-1
SCALE 2X



SECTION D-D B3-2
SCALE 2X

#67630

RELEASED
2010-09-27

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4037	REV. C
MFG. APPR.		TITLE	SHEET 3 OF 3
APPROVED		CROSSBEAM	SCALE
DE APPR.			NTS
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DART AEROSPACE LTD		Work Order: 67630
Description: Aft Crossbeam		Part Number: D4037-1
Inspection Dwg: D4037	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.530	+/-0.010	0.526	✓		Vern D-6	GA-01 / GA-08
0.25	+/-0.030	0.255	✓		Mic	118-120
2.00	+/-0.030	2.004	✓		Mic	GA-02
2.75	+/-0.030	2.753	✓		Vern	GA-01
1.00	+/-0.030	0.990	✓		"	"
R0.032	+/-0.010	R0.032	✓		R-6	ref.
42.87	+/-0.030	42.875	✓		TAPE	GA-12
1.38	+/-0.030	1.375	✓		Vern	GA-01
1.750	+/-0.010	1.750	✓		"	"
2.125	+/-0.010	2.125	✓		"	"
2.250	+/-0.010	2.250	✓		"	"
0.875	+/-0.010	0.874	✓		"	"
0.875	+/-0.010	0.874	✓		"	"
6.000	+/-0.010	6.000	✓		"	"
1.125	+/-0.010	1.125	✓		"	"
0.86	+/-0.030	0.855	✓		"	"
1.38	+/-0.030	1.376	✓			
1.38	+/-0.030	1.376	✓			
8.04	+/-0.030	8.045	✓		Vern	CNC-03
5.29	+/-0.030	5.291	✓		"	"
6.00	+/-0.030	6.000	✓		"	"
Ø0.316	+0.006/-0.001	Ø0.317	✓		Vern	GA-01
Ø0.391	+0.006/-0.001	Ø0.391	✓		"	"

Measured by: H.A	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 11/03/30	Date: 11/04/01	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	<i>[Signature]</i>

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